



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D2616-2
Job Sheet 194300



Part No: D2616-2

Job Qty: 20 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/30/19

Job Tracking No:

Due Date: 6/24/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2616-2 REV:E IPP REV:D (REPROGRAMMED FOR HAAS 5) 18.08.09 RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs		6/24/19	0.00	2.00	Bandsaw - 1		19-06-13
110	HAAS 4 Axis - B4B	20 pcs		6/24/19	0.00	0.00	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	20 pcs		6/24/19	0.00	0.00	QC 8 - 12		19/06/14
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
140	Handfinish - 1-1 Chemical-B4B	20 pcs		6/24/19	0.00	0.37	Handfinish - 1 - 1 - B4B		



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S190131



Part: D2616-2

Job No: 194300

Serial No/Batch: S190131

Revision: E

Inspector:

Exp Date:

Instructions: Certificate of Conformance only

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ JUN 17 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	20 pcs	6/24/19	0.00 0.72	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	13/19-6-18.
				Powdercoat - 4 - B4B	
160 QC 3	20 pcs	6/24/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	★ JUN 18 2019
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	

Entered: _____ Date: _____



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Other/Details:					

170 Small Fab - 2 - B4B	20 pcs	6/24/19	0.00 1.39	QC 3 - 40	
				QC 3 - 19	
				Small Fab - 1 - B4B	DAS
				Small Fab - 2 - B4B	71
				Small Fab - 3 - B4B	9-89
				Small Fab - 4 - B4B	19-6-18
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
180 QC 5	20 pcs	6/24/19	0.00 0.00	Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	JUN 19 2019
				QC 5 - 40	DAS 40 9-89
190 Packaging 3-1 - Stock - B4B	20 pcs	6/24/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	5-15-19
				Packaging 3 - 5 - B4B	9-89 74 DAS JUN 19 2019
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	

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Other/Details:					

200 QC 21 - SA	20 pcs	6/24/19	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	JUN 28 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - Bandsaw - Cut blanks: 2.000" long +0.030" -0.000"

Descriptions: 110 - HAAS CNC vertical machine #5 - 1-Machine as per folio FB477 & DWG D2616 2-Tumble & Deburr

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) - Note:Mask large hole START TIME: _____

160 - QC3- Inspect Part Finish)

170 - Small Fab - 1-Coat bearing in light oil 2-Press Bearing in D2616-2 3-Stack as per Dwg D2616 using DT8019 4-Touch up paint if required

180 - QC5- Inspect part completeness to step on W/O)

190 - Identify as per dwg & Stock Location: _____

200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X01.250	6061-T6 Bar 2.50 X 1.25	3.7400 ft (.187 ea)	100-Bandsaw - 1	S156614
D2611	Bearing	20 pcs (1 ea)	170-Small Fab - 2 - B4B	S152120

ST008

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.500X01.250	4	12	0
170-Small Fab - 2 - B4B	D2611	20	22	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	0.250inches ± 0.010	0.260 0.240	.251	
2	Mounting Lug	1.250inches ± 0.010	1.260 1.240	1.251	
3	Mounting Lug	0.375inches ± 0.010	0.385 0.365	.372	
4	Mounting Lug	0.625inches ± 0.010	0.635 0.615	.624	
5	Mounting Lug	0.257inches + 0.006 - 0.001	0.263 0.256	.258	
6	Mounting Lug	1.000inches ± 0.010	1.010 0.990	1.000	
7	Mounting Lug	2.000inches ± 0.010	2.010 1.990	2.000	
8	Mounting Lug	1.125inches ± 0.010	1.135 1.115	1.125	
9	Mounting Lug	0.313inches ± 0.010	0.323 0.303	.314	
10	Mounting Lug	17.000Degrees ± 0.500	17.500 16.500	17°	
11	Mounting Lug	1.259inches ± 0.010	1.269 1.249	1.261	
12	Mounting Lug	0.250inches ± 0.010	0.260 0.240	.250	
13	Mounting Lug	0.063inches ± 0.010	0.073 0.053	.063	
14	Mounting Lug	0.8115inches + 0.0005 - 0.0000	0.8120 0.8115	.812	

Plex 4/30/19 9:10 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



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